

1 5/15

SLIT

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22493
<b>Description:</b> Bearpaw Kit (19" x 24")	<b>Part Number:</b>	K10008
<b>Dwg:</b> D2432 Rev. F3	<b>Qty:</b>	15 Kits
<b>Ref:</b> K10008 Rev. E; DSK086-5 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler <b>Note: (1) K10008 Kit consists of Qty (2) D2432F Dwg not required</b>	HA	05.02.21	15																																																
2	DC	Photocopy bluefile: K10008 D206-559-013 D350-578-011 D315-670-011 D427-659-011 and create labels per PPP K10008 CHG006 <b>(Bag Bluefiles separately)</b>	WR 13 HA	05.03.09	1																																																
3	GA	<b>Cut 2 blanks per (1) K10008 Kit</b> Cut blank: 19.50" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5 Material: Black UHMW 1" (MUHMWB10) Batch: M15426	me	05/03/09	1																																																
4	MV	Inspect material for defects or damage prior to machining	me	05/03/09	26																																																
5	MV	Machine as per Folio D2432 and Dwg D2432 <b>Identify as D2432F</b>	me	05/03/09	1																																																
6	QC2	Inspect parts as they come off the CNC machine	me	05/03/09	1																																																
7	MV	Deburr	me	05/03/09	1																																																
8	QC8 & 5	Second inspection	EE	05.03.09	1																																																
9	KP	<b>Pick: Packing Kit (Note: D2432F is on the BOM as material from step 3)</b> <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>6</td><td>D2182B050</td><td>Rubber Cushion</td><td>B20434</td></tr><tr><td>12</td><td>D2274</td><td>Radius Block</td><td>B20927</td></tr><tr><td>2</td><td>D2432F</td><td>24" Bearpaw</td><td>B22493</td></tr><tr><td>6</td><td>D2438</td><td>Clamp</td><td>B21189</td></tr><tr><td>12</td><td>D2529</td><td>Washer</td><td>B21587A</td></tr><tr><td>6</td><td>D2732-050</td><td>Rubber Cushion</td><td>B20433</td></tr><tr><td>12</td><td>AN4-15A</td><td>Bolt</td><td>m8525/m1445/m1454</td></tr><tr><td>12</td><td>AN4-17A</td><td>Bolt</td><td>m12692</td></tr><tr><td>24</td><td>AN960JD416</td><td>Washer</td><td>m15993</td></tr><tr><td>12</td><td>MS21042L4</td><td>Nut (or -4)</td><td>m15020</td></tr><tr><td>1</td><td colspan="3">Paperwork package from Step 2</td></tr></table>	Qty	Part Number	Description	Batch	6	D2182B050	Rubber Cushion	B20434	12	D2274	Radius Block	B20927	2	D2432F	24" Bearpaw	B22493	6	D2438	Clamp	B21189	12	D2529	Washer	B21587A	6	D2732-050	Rubber Cushion	B20433	12	AN4-15A	Bolt	m8525/m1445/m1454	12	AN4-17A	Bolt	m12692	24	AN960JD416	Washer	m15993	12	MS21042L4	Nut (or -4)	m15020	1	Paperwork package from Step 2					
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10	QC4	Inspect Kit for 100% Completeness on the W/O	CL	05/03/09	1																																																
11	PK	Identify and pack for shipping as per PPP K10008	REV E	05/03/10	1																																																
12	AC	Cost / part 224.20	JCF	05.03.10	1																																																
13	DC	Close W/O 224.20 Inspect Level 21	HA	05.03.10	1																																																

Rev	Date	Change	Revised By	Approved
F	02.05.22	Chg 005 (MPP 2245)	NG	
G	02.07.11	Replace D2639 (D2981-0200-1600) with D2732-050	KJ	
H	02.08.15	Added D427-659 to Step 2	KJ	
I	03.02.21	Reformat; Incorporated D2432F	KJ/RF	
J	04.02.17	Blank size changed on Step 3	KJ/JLM	

By 05-03-10

RELEASER





DART AEROSPACE LTD		Work Order:	22493
Description: Bearpaw		Part Number:	D2432F
Inspection Dwg: D2432	Rev: F3	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060	✓	Uem	
B	5.500	+/-0.030	5.500	✓	Uem	
C	0.200	+/-0.030	0.203	✓	Uem	
D	0.25 x 45°	+/-0.030	0.230x45°	✓	Uem	
E	R0.250	+/-0.030	R0.250	✓	R-G	
F	0.250	+/-0.010	0.254	✓	Uem	
G	0.625	+/-0.030	0.612	✓	Uem	
H	0.375	+/-0.010	0.382	✓	Uem	
I	0.950	+0.030/0.010	0.960	✓	Uem	
J	19.000	+/-0.030	19.000	✓	M-Tape	
K	3.14	+/-0.030	3.124	✓	Uem	
L	3.28	+/-0.030	3.270	✓	Uem	
M	Ø0.260	+0.005/-0.000	Ø0.260	✓	Uem	
N	Ø0.93	+/-0.030	Ø.929	✓	Uem	
O	0.30	+0.030/-0.000	0.305	✓	Uem	
P	23.750	+/-0.030	23.750	✓	M-Tape	
Q	7.375	+/-0.030	7.375	✓	Uem M-Tape	
R	4.250	+/-0.010	4.250	✓	M-Tape	
S	2.000	+/-0.030	2.000	✓	Uem	
T	9.000	+/-0.010	9.000	✓	M-Tape	
U	9.000	+/-0.010	9.000	✓	M-Tape	
V	0.375	+/-0.010	0.380	✓	Uem	

Measured by: <i>me</i>	Audited by: <i>SA</i>	Prototype Approval:	N/A
Date: 05/03/07	Date: 05/03/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	<i>[Signature]</i>

